



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D119-646-041
Job Sheet 174917



Part No: D119-646-041

Job Qty: 1 ea

Part Name: AW119 Replacement Skidtube with Wearpads - Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/23/18

Job Tracking No:

Due Date: 6/27/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG IIN-D119-646 REV D, D3887-041 REV E SHEETS 1,2,5,7,8,10,11 IPP RevA: New issue DD verified by:EC IPP rev B 10.02.22 per PAR 09-043 EC verified by:DD IPP REVC 12.11.05 (DEOD3887-B-1)(ecn 12-675) DD verf:JLM IPP REV:D 13.03.20 per chg003 ECN13-534 DD verf:JLM IPP REV:E 17.05.19 as per dwg D3887 rev.e DD verf:JFS

Ship Via:

Bill of Materials



Container No: S059831



Part: D119-646-041

Job No: 174917

Serial No/Batch: S059831

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/11/18

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/26/18	0.00	0.00	Start Up Skid tubes-1		J.Y.
110	Skid tubes	1 pcs		6/26/18	0.00	0.25	Skid tubes-1		J.Y.
120	HandFinish	1 pcs		6/26/18	0.00	0.83	HandFinish1		SA 18-04-17
121	QC	1 pcs		6/26/18	0.00	0.00	QC7-1		BE
122	QC	1 pcs		6/26/18	0.00	0.00	QC5		BE
130	Skid tubes	1 pcs		6/26/18	0.00	1.54	Skid tubes-1		DD 18-04-17
135	QC	1 pcs		6/26/18	0.00	0.00	QC5		BE
140	Skid tubes	1 pcs		6/26/18	0.00	1.47	Skid tubes-1		BE
150	QC	1 pcs		6/26/18	0.00	0.00	QC5		BE
160	Skid tubes	1 pcs		6/26/18	0.00	1.61	Skid tubes-1		DD 18-04-17
170	QC	1 pcs		6/26/18	0.00	0.00	QC5		DD 18-04-17
180	QC	1 pcs		6/26/18	0.00	0.00	QC10		DD 18-04-17
190	HandFinish	1 pcs		6/26/18	0.00	0.83	HandFinish2		BE 18-06-28
200	Powdercoat	1 pcs		6/26/18	0.00	0.22	Powdercoat1		DD 18-06-28
210	QC	1 pcs		6/26/18	0.00	0.00	QC3		BE 18-06-28
220	HandFinish	1 pcs		6/26/18	0.00	3.83	HandFinish4		BE 18-06-28
240	HandFinish	1 pcs		6/27/18	0.00	2.00	HandFinish4		BE 18-07-09
245	QC	1 pcs		6/27/18	0.00	0.00	QC5		BE 18-07-09
255	DC	1 pcs		6/27/18	0.00	0.00	DC		DAS 18-08-09
260	Packaging	1 pcs		6/27/18	0.00	0.00	Packaging3-1		21 JUL 10 2018
270	QC21-FG	1 Ea		6/27/18	0.00	0.00	QC21		21 JUL 10 2018

Part Op 110 - 1- inspect Mat'L D2500-1-190 for damage 2-Cut tube to length as per dwg D3887 (154.8") 3- Ensure squareness of Descriptions: ends and scribe batch#

130 - 1- Install drill Jig DT9477 drill X-bolt spacer pilot holes using 3/16" drill first side only. 2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes using DT9477 4- Open crossbolt spacer holes to finished size as per dwg D3887 (section D-D and E-E) ***DO NOT OPEN FWD Saddles Holes*** 5- Deburr, blow out chips from inside of tube. 6- Bond web in place as per Dwg D3887 & QSI 015. A/R 138787 2018/01/22

140 - 1- Bend FWD end of tube using bender 1 and POLIO 31 bend prog. D3887. ***Must use bending aid DT9544, ensure proper positioning*** 2- Cut FWD end of tube as per dwg D3887. ***Verify measurement*** 3- Buff out marks left from bending 4- Drill FWD cap holes using DT8215. Open FWD & AFT cap holes to 0.208" 5- Open FWD saddle holes to finished size as per dwg D3887 6- Drill FWD x-bolt spacer holes using DT9816 and open to finished size. (verify measurement) 7- Drill Tow ring hole, using DT10047 locate from FWD saddle hole. (verify measurement). Open to finished size. 8- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. 9- C'sink FWD cap hole as per detail "C" 10- Drill holes for wearpads using DT8931, open to 0.297". 11- Countersink crossbolt spacer holes, and prepare tube for welding, deburr. 12- Deburr and blow out chips from inside of tube.

160 - NOTE: TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDLING FIXTURE, IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3887. Remember to back drill each hole before welding the other side. Use aluminum rod A/R 2-Grind cross bolt welds flush as per Dwg D3887. Ensure no pin hole. 3-Counterbore 5/16" x 0.750" deep as per Dwg D3887. 4- Deburr & Scribe batch # on Aft end of tube.

170 - TEST FIT USING FIXTURE DT10091.

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - ***MASK AREA SHOWN ON SHEET 7, NOTE 9*** START TIME: 9:00 AM OVEN TEMPERATURE:

3:20 PM FINISH TIME: 5:30 PM

220 - 1-Install inserts as per Dwg D3887.

240 - 1-Install inserts as per Dwg D3887. 2-Install wearpads, gaskets as per Dwg D3887. Put sikaflex in insert before installing bolts and washers A/R Sikaflex-240/-291 1138787 Sikaflex expire date: 18/12 3-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 1138843 4 -Inspect for foreign objects as per QSI 024 5 -Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 1138787 Sikaflex expire date: 18/12 6 -Install insert in D2855- Cap. Install cap and seal with Sikaflex.

Clean excess adhesive. A/R Sikaflex-240/-291 1138787 Sikaflex expire date: 18/12 7- Wing Walk as per dwg and QSI Batch: 1138787 07-09-18

255 - Photocopy bluefile & type labels per PPP D119-646-041 CHG004

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n -I' Beam Tube 4"	1 Ea (1 ea)	90-Start up Operation	5037168
D2579	Crossbolt Spacer	2 Ea (2 ea)	140-Skidtubes	50666 5040524
D3885-1	Standard Web	1 Ea (1 ea)	140-Skidtubes	5161481
D2855-5	Cap	1 Ea (1 ea)	160-Skidtubes	5066894
D3681-1	Spacer	12 Ea (12 ea)	160-Skidtubes	5022530
D3903-1	Spacer	12 Ea (12 ea)	160-Skidtubes	5062330
ALS4-1032-130	Rivnut	33 Ea (33 ea)	240-HandFinish	5007279
ALS4-1032-225	Rivnut	1 Ea (1 ea)	240-HandFinish	5058188
AN3C4A	Bolt	6 Ea (6 ea)	240-HandFinish	5068642
AN3C5A	Bolt	26 Ea (26 ea)	240-HandFinish	5057153
D2855-3	Cap	1 Ea (1 ea)	240-HandFinish	5066002
D3492-5	Plug	24 Ea (24 ea)	240-HandFinish	5060337
D3672-1	Washer, Phenolic	2 Ea (2 ea)	240-HandFinish	5150074
D3847-1	Wearpad	5 Ea (5 ea)	240-HandFinish	5057444
D3847-11	Wearpad	1 Ea (1 ea)	240-HandFinish	5026852
MS24694-C52	Screw	2 Ea (2 ea)	240-HandFinish	1x FM 13795 / 5067269-1 x1
NAS1149C0332R	Washer	32 Ea (32 ea)	240-HandFinish	5056493
NAS1611-005	O-Ring	24 Ea (24 ea)	240-HandFinish	5057657

Job Allocations

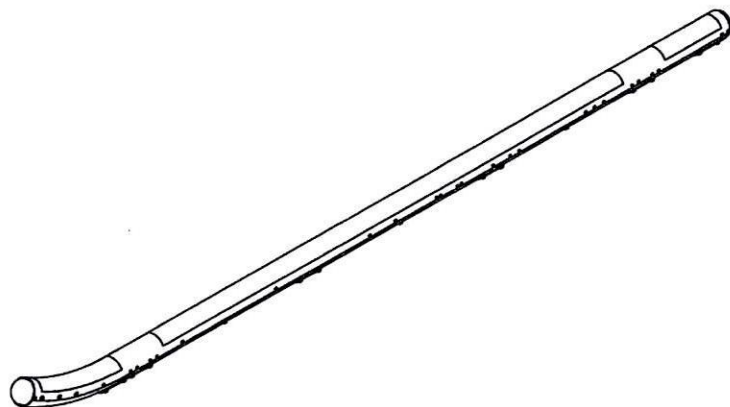
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-190	1	85	0
140-Skidtubes	D2579	2	89	0
	D3885-1	1	16	0
160-Skidtubes	D2855-5	1	94	0
	D3681-1	12	248	0
	D3903-1	12	37	0
240-HandFinish	ALS4-1032-130	33	7,007	0
	ALS4-1032-225	1	1,148	0
	AN3C4A	6	2,521	0
	AN3C5A	26	189	0
	D2855-3	1	9	0
	D3492-5	24	26	0
	D3672-1	2	1,071	0
	D3847-1	5	28	0
	D3847-11	1	19	0
	MS24694-C52	2	61	0
	NAS1149C0332R	32	4,896	0
	NAS1611-005	24	235	0

Part Specifications

Specifications could not be found.

Plex 3/23/18 9:20 AM Dart.Gagnon.Michelle

004259



D3887-041 STANDARD SKIDTUBE ASSY WITH WEARPAD(SHOWN)
D3887-043 STANDARD SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)
D3887-045 STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 174917

MAR 27 2018

E	COMPLETE REDRAW, ADDED ASSY DETAILS -3, -051 & -053, SEE PREVIOUS REV. FOR DETAIL. POWDER COAT REMOVED FROM SADDLE AREA SEE DETAIL F. REF PARTS-421 ADDED STRUCTURAL PROVISIONS TO ALLOW FOR THE INSTALLATION OF THE D119-846-313/314 SKIDTUBE PROTECTOR KIT. REF PART17-577 CHANGE QTY OF D2855-3, ADDED D2855-5 CAP ASSEMBLIES, ADDED INSTRUCTIONS TO LOCATE INSERT HOLE FOR D2855-5 CAP. REF PART17-583	AJS / WK	17.02.03
D	REVISED BEND TOLERANCES FOR MANUFACTURABILITY, 135.07 WAS 134.04 (ZN D5-8), ADD 5.07 (ZN C2-8), ADD 116.8 (ZN D5-8), DELETE GASKETS (BOM, SH 2)	DB	13.09.20
C	(SHT1, P/L ZN C2-2, C3-2, C4-2) ITEM 13, QTY 2 WAS 4, ITEM 42, QTY 32 WAS 34, ITEM 44, QTY 30 WAS 32, ADD ITEM 46, MS24894-C32 WAS AN3C5A, 2 PLCS, (ZN C1-5, C1-6, B4-7) 0.201 CSK 0.0.385 X 100 WAS 0.0.214 THRU, ADDED DETAIL F (ZN C8-5, C8-6, B8-7), ADD ITEM 10, D2579 CROSS BOLT SPACER (ZN D4-1, A8-7)	DB	13.02.19
B	ALS4-1032-130 WAS AELS-1032-130 (ZN C4-1, C5-7, C3-7); ADD D78931 (ZN A8-1); ADD 134.04 (ZN C4-8); D2855-3 WAS D2575 (ZN D4-1, C7-2, C2-2, C7-3, C2-3, C7-4, C2-4); AN3C5A WAS AN3C4A (ZN C8-2, C2-2, C8-3, C2-3, C8-4, C2-4); 0.0.313 WAS 0.0.328 (ZN C4-5, C4-5, C2-7 & B3-7) REVISED NOTE W (ZN B3-7)	RF	09.08.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	WK		
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3887	SHEET 1 OF 11
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 STD SKIDTUBE ASSY	NTS
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 2017-05-08
 17-519

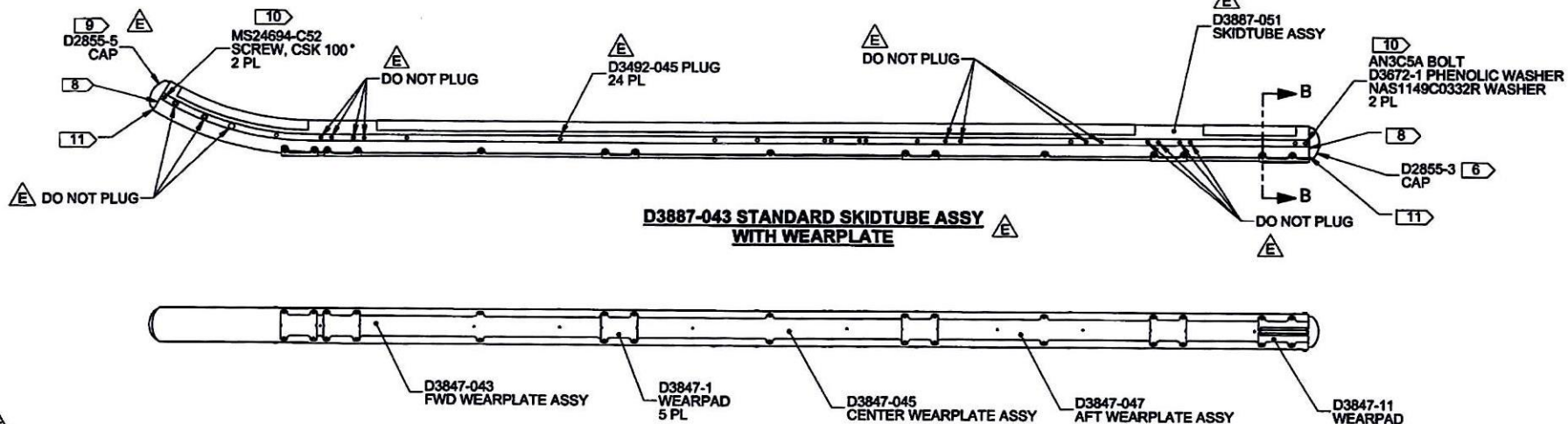
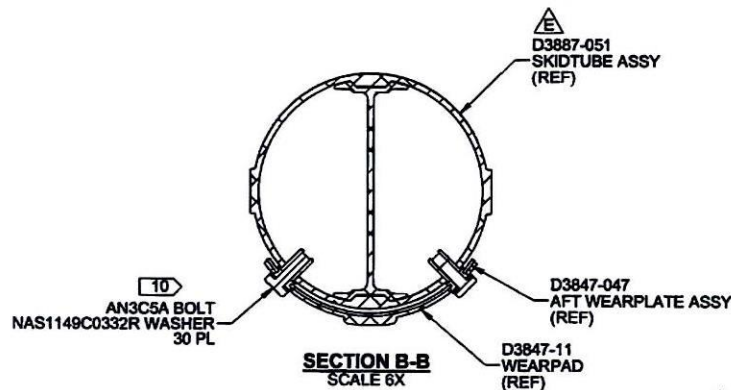
D

1

APPROVED

A

ITEM	QTY	P/N	DESCRIPTION
	X	D3887-043	STANDARD SKIDTUBE ASSY WITH WEARPLATE
1	1	D2855-3	CAP ASSY
2	1	D2855-5	CAP ASSY
3	24	D3492-045	PLUG ASSY
4	2	D3672-1	PHENOLIC WASHER
5	1	D3847-043	FWD WEARPLATE ASSY
6	1	D3847-045	CENTER WEARPLATE ASSY
7	1	D3847-047	AFT WEARPLATE ASSY
8	5	D3847-1	WEARPAD
9	1	D3847-11	WEARPAD
10	1	D3887-051	SKIDTUBE ASSY
11	1	ALS4-1032-225	INSERT
12	32	AN3C5A	BOLT
13	2	MS24694-C52	SCREW, CSK 100°
14	32	NAS1149C0332R	WASHER



- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3887-043" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
 - 7) WEIGHT: 37.0 lbs
 - 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
 - 9) USE D3887-051 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP. OPEN HOLE TO Ø0.297, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
 - 10) SEAL FASTENERS WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
 - 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

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MFG. APPR.	DD	D3887	SHEET 3 OF 11
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DE APPR.	DS	A119 STD SKIDTUBE ASSY	NTS
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ITEM	QTY -045	P/N	DESCRIPTION
	X	D3887-045	STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE
1	1	D2855-3	CAP ASSY
2	1	D2855-5	CAP ASSY
3	8	D3492-045	PLUG
4	2	D3672-1	PHENOLIC WASHER
5	1	D3849-041	FWD WEARPLATE ASSY, STD GEAR
6	1	D3849-043	AFT WEARPLATE ASSY, STD GEAR
7	1	D3887-053	SKIDTUBE ASSY
8	16	D3904-1	WASHER
9	1	ALS4-1032-225	INSERT
10	8	AN3C48A	BOLT
11	2	AN3C5A	BOLT
12	8	MS21043-3	NUT, SELF-LOCKING
13	2	MS24694-C52	SCREW, CSK 100°
14	2	NAS1149C0332R	WASHER

SECTION C-C
SCALE 4X

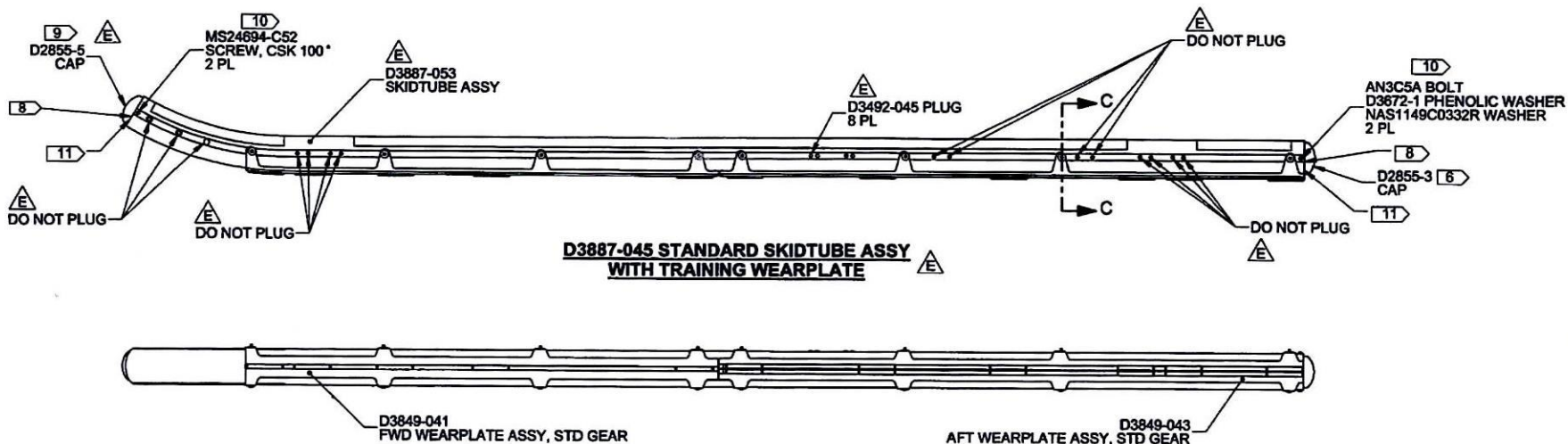
D3887-045 STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3887-045" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
 7) WEIGHT: 38.1 lbs
 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
 9) USE D3887-053 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP. OPEN HOLE TO Ø0.297, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
 10) SEAL FASTENERS WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

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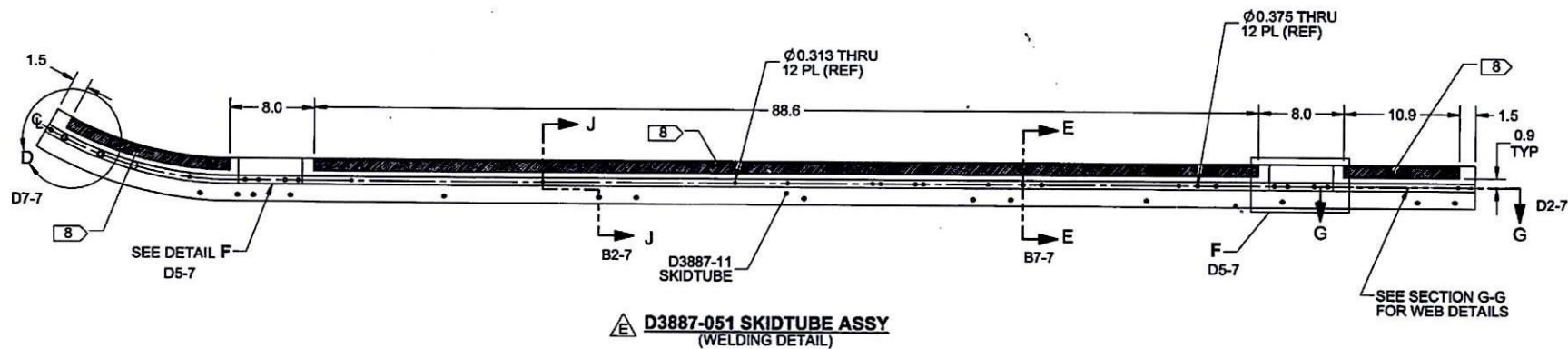
- 1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3887-045" AND BATCH NUMBER PER QSI 044 6.4
ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
7) WEIGHT: 38.1 lbs
8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
9) USE D3887-053 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP. OPEN HOLE TO
Ø0.297, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AK57-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
10) SEAL FASTENERS WITH SIKAFLEX -241-/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

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ITEM	QTY -051	P/N	DESCRIPTION
	X	D3887-051	SKIDTUBE ASSY
1	2	D2579	CROSS BOLT SPACER
2	12	D3681-1	CROSS BOLT SPACER
3	1	D3885-1	STANDARD WEB
4	1	D3887-11	SKIDTUBE
5	12	D3903-1	CROSS BOLT SPACER
6	30	ALS4-1032-130	INSERT



NOTES:

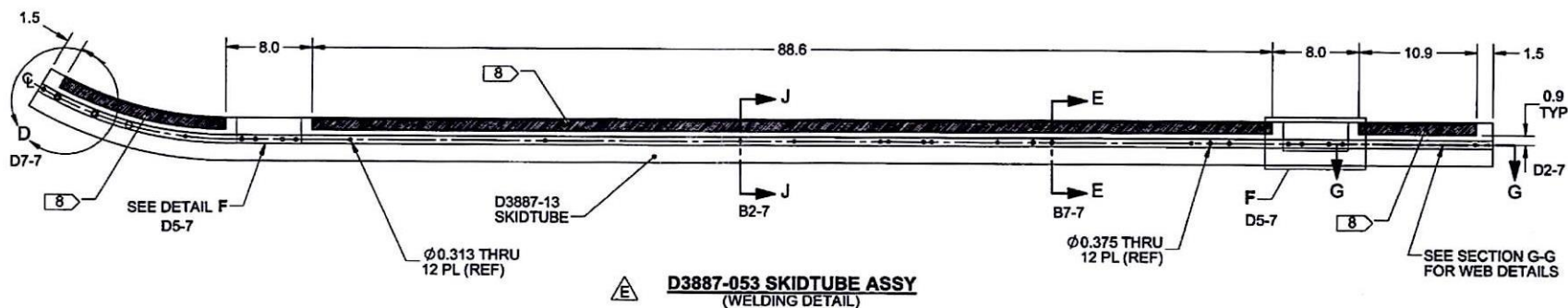
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50 ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

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ITEM	QTY -053	P/N	DESCRIPTION
	X	D3887-053	SKIDTUBE ASSY
1	2	D2579	CROSS BOLT SPACER
2	12	D3881-1	CROSS BOLT SPACER
3	1	D3885-1	STANDARD WEB
4	1	D3887-13	SKIDTUBE
5	12	D3903-1	CROSS BOLT SPACER



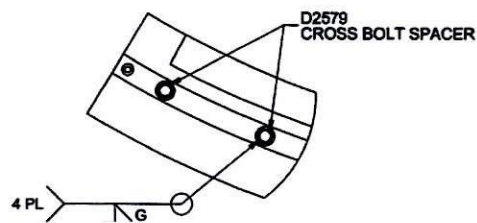
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50 ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

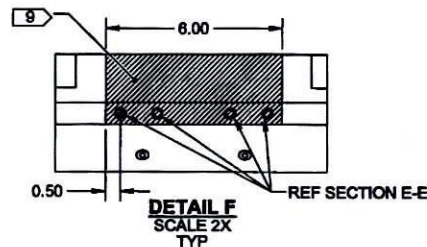
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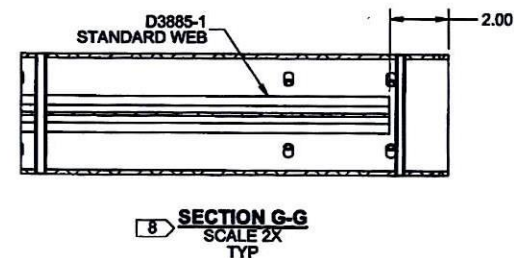
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MFG. APPR.	DD	D3887	SHEET 8 OF 11
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 STD SKIDTUBE ASSY	NTS
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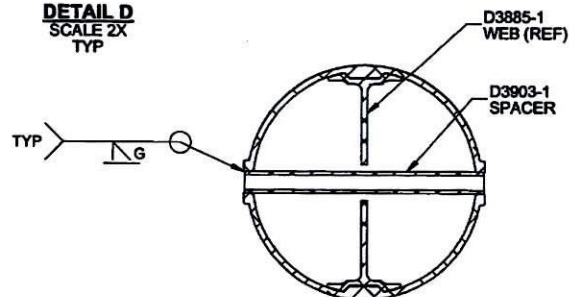
DETAIL D
SCALE 2X
TYP



DETAIL F
SCALE 2X
TYP

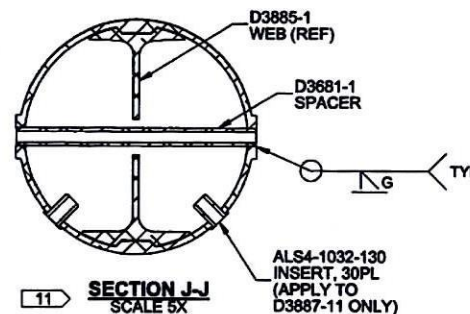


SECTION G-G
SCALE 2X
TYP



SECTION E-E
SCALE 5X
TYP

(FOR 12X $\phi 0.375$ HOLES
PER SKIDTUBE)



SECTION J-J
SCALE 5X
TYP

(FOR 12X $\phi 0.313$ HOLES
PER SKIDTUBE)

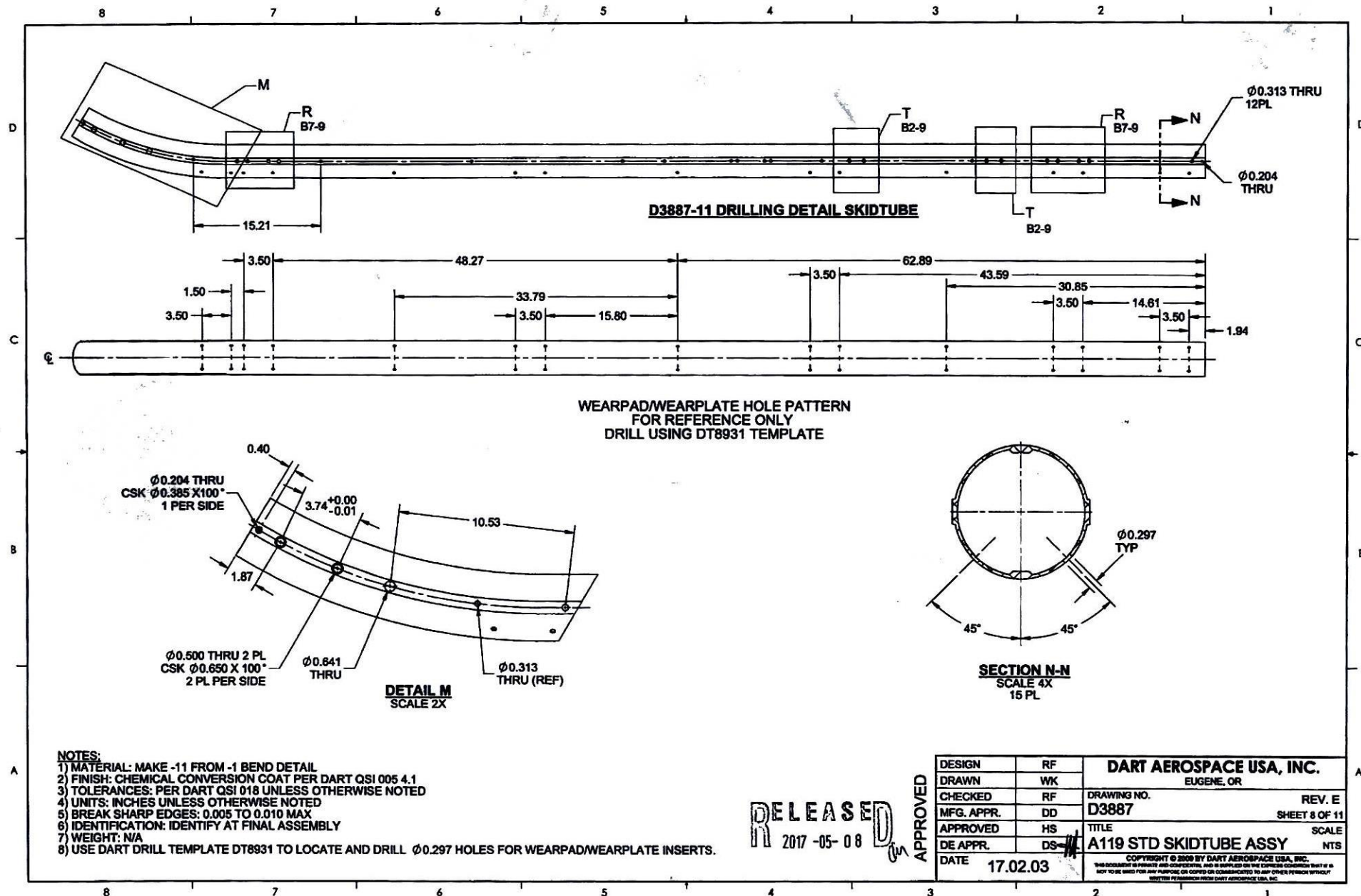
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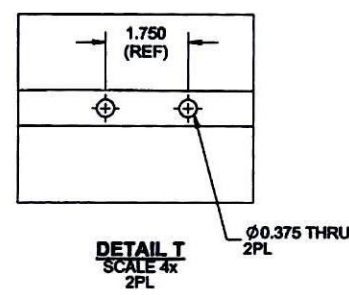
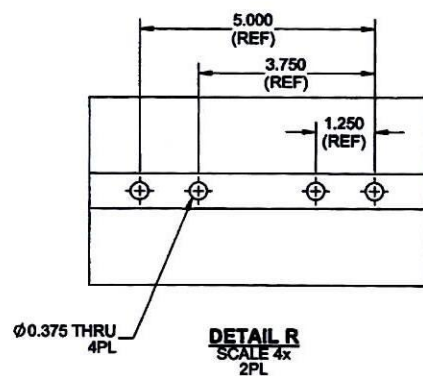
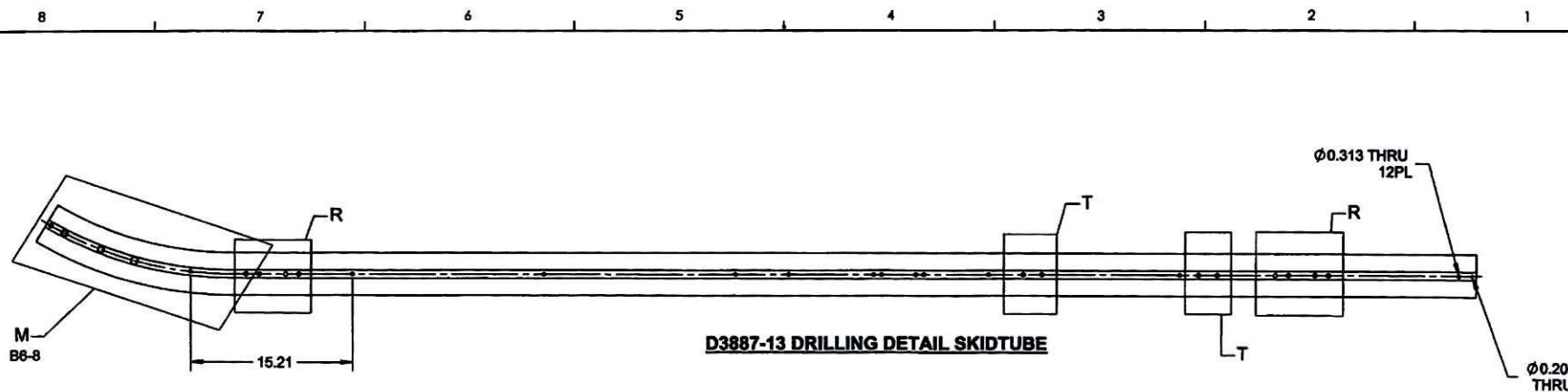
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) INSERT D3885-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
- 9) MASK THIS AREA AND DO NOT POWDER COAT
- 10) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION E-E $\phi 0.375$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.475 \times 45^\circ$
 - ii) INSERT D3903-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) C'BORE TO $\phi 0.313 \times 0.75$ DEEP
 - v) DEBURR HOLES
- 11) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION J-J $\phi 0.313$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.354 \times 45^\circ$ OR 0.050 DEEP $\times 45^\circ$ (BOTH SIDES)
 - ii) INSERT D3681-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) DEBURR HOLES
- 12) WELD PER DART QSI 004

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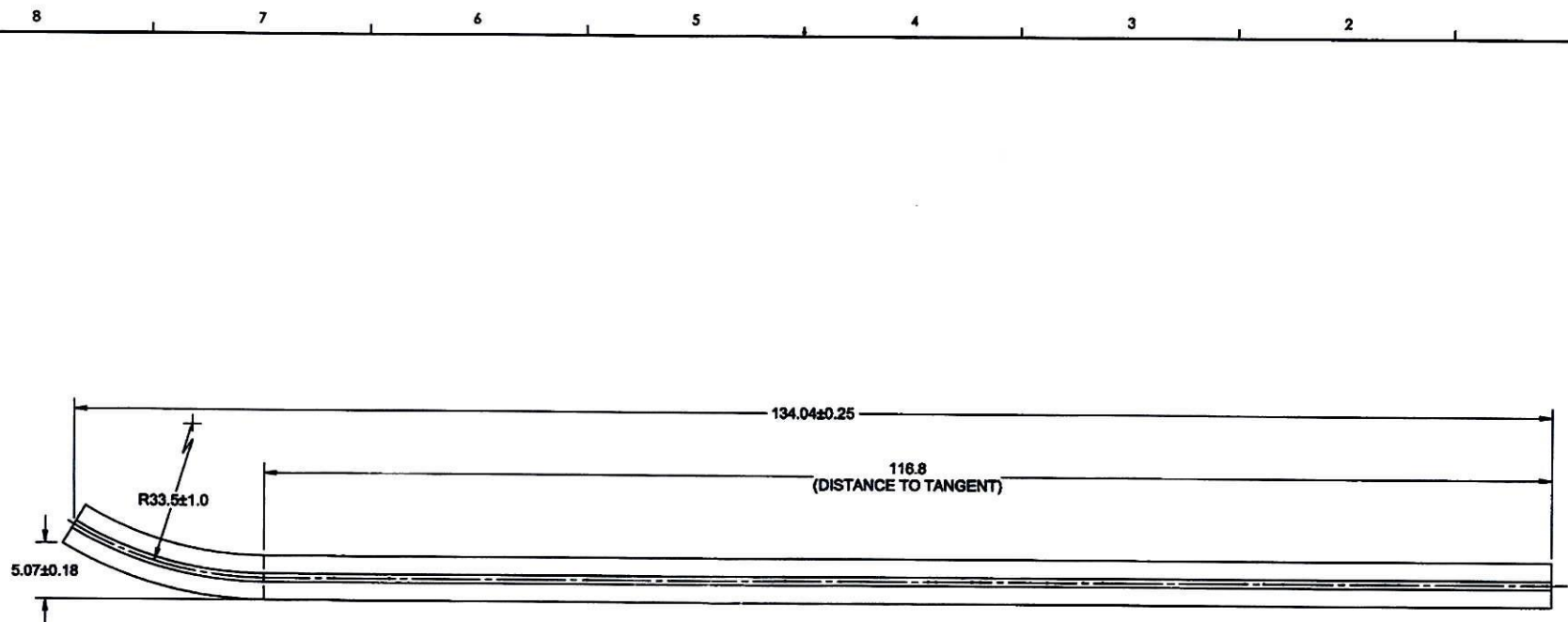




- NOTES:
- 1) MATERIAL: MAKE -13 FROM -1 BEND DETAIL
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A

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D3887-1 BEND DETAIL SKIDTUBE

NOTES:

- 1) MATERIAL: MAKE -1 BEND DETAIL FROM -3 PILOT HOLE DETAIL
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

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